

# Work Order ID 63444

Tuesday, November 02, 2010 8:23:22 AM



Page 1

Item ID:	D3065-1	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Step Spacer					
Start Date:	11/2/2010	Start Qty:	30.00		Cust Item ID:	
Required Date:	11/9/2010	Req'd Qty:	30.00		Customer:	
Reference:						

Approvals:	Process Plan:		Date:	10-11-02	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3065	Rev B

100		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3065	<input type="checkbox"/> Dwg Rev: <u>B</u>	<input type="checkbox"/> Prog Rev: <u>B</u>	<input type="checkbox"/> 2-					
<u>2074</u> <u>240</u>	Deburr as required								

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00							
Quality Control									

120	QC8- Inspect parts - second check	0.00							
QC	Memo	0.00							
Quality Control									

counter

8/10/10/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**Dart Aerospace Ltd**

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Page 3

Item ID: D3065-1

Accept



Setup Start



Revisor ID:

Stop



Item Name: Step Spacer

Start Date: 11/2/2010 Start Qty: 30.00



Cust Item ID:

Required Date: 11/9/2010 Req'd Qty: 30.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  HandFinish Hand Finishing	Chemical Conversion Coat per QS1005 4.1  Memo	0.00  0.00				37		BR 10-11-8	
170  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00				37			
180  Packaging Packaging	Identify as per dwg & Stock Location: <u>GA</u>  Memo	0.00  0.00				37			

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Page 4

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Setup Start



Revision ID:

Stop



Item Name: Step Spacer

Start Date: 11/2/2010 Start Qty: 30.00



Cust Item ID:

Required Date: 11/9/2010 Req'd Qty: 30.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/11/08

10-11-08  
(37)

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# Picklist Print

Tuesday, November 02, 2010 8:23:26 AM

Page 1

Work Order ID: 63444



Parent Item: D3065-1



Parent Item Name: Step Space

Start Date: 11/2/2010

Required Date: 11/9/2010

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP: ☐ C02.11.01 ☐ Incorporated D3066-1 IPP ☐ KJ/RF ☐  
IPP: ☐ D06.04.25 ☐ Water jet EC ☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M2024T3S.040		Purchased	No			100	sf	298.0400	0.1238	3.909474	4.5		
											B10-11-2		

2024-T3 .040 sheet

Location	Loc Qty	Loc Code
MAT	71.6	
114415	71.6	
MAT22	226.44	
110305	21.93	
111786	9.66	
112291	28.25	
112331	52	
113162	114.6	

113162

36

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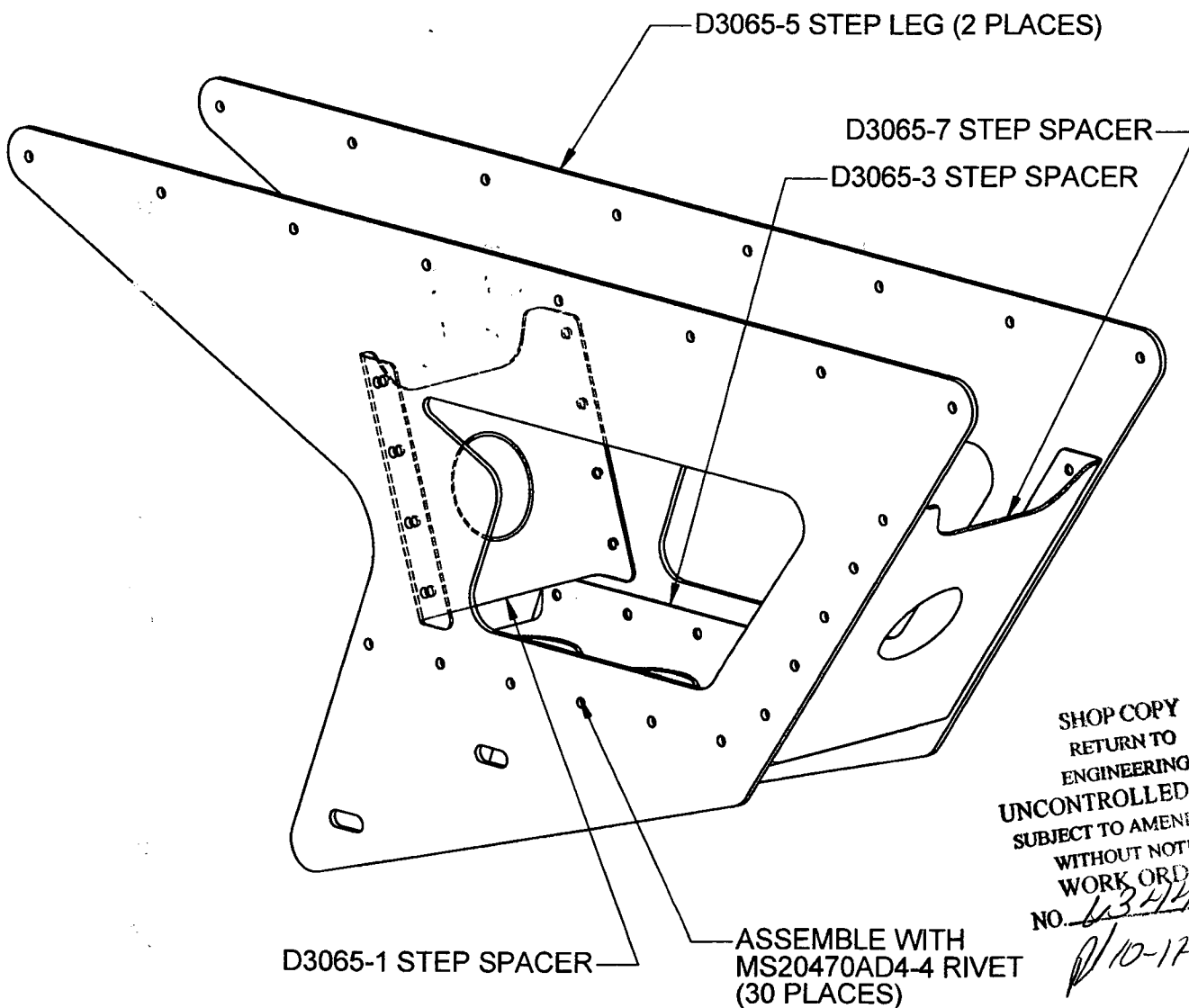
**NOTE:** Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3065</b>	REV. B SHEET 1 OF 5
DATE <b>06.05.23</b>		TITLE <b>STEP LEG ASSEMBLY</b>	SCALE 1:2
A	02.09.11	NEW ISSUE	
B	06.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5	

RELEASED

06.06.20 *[Signature]*



## D3065-041 STEP LEG ASSEMBLY

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

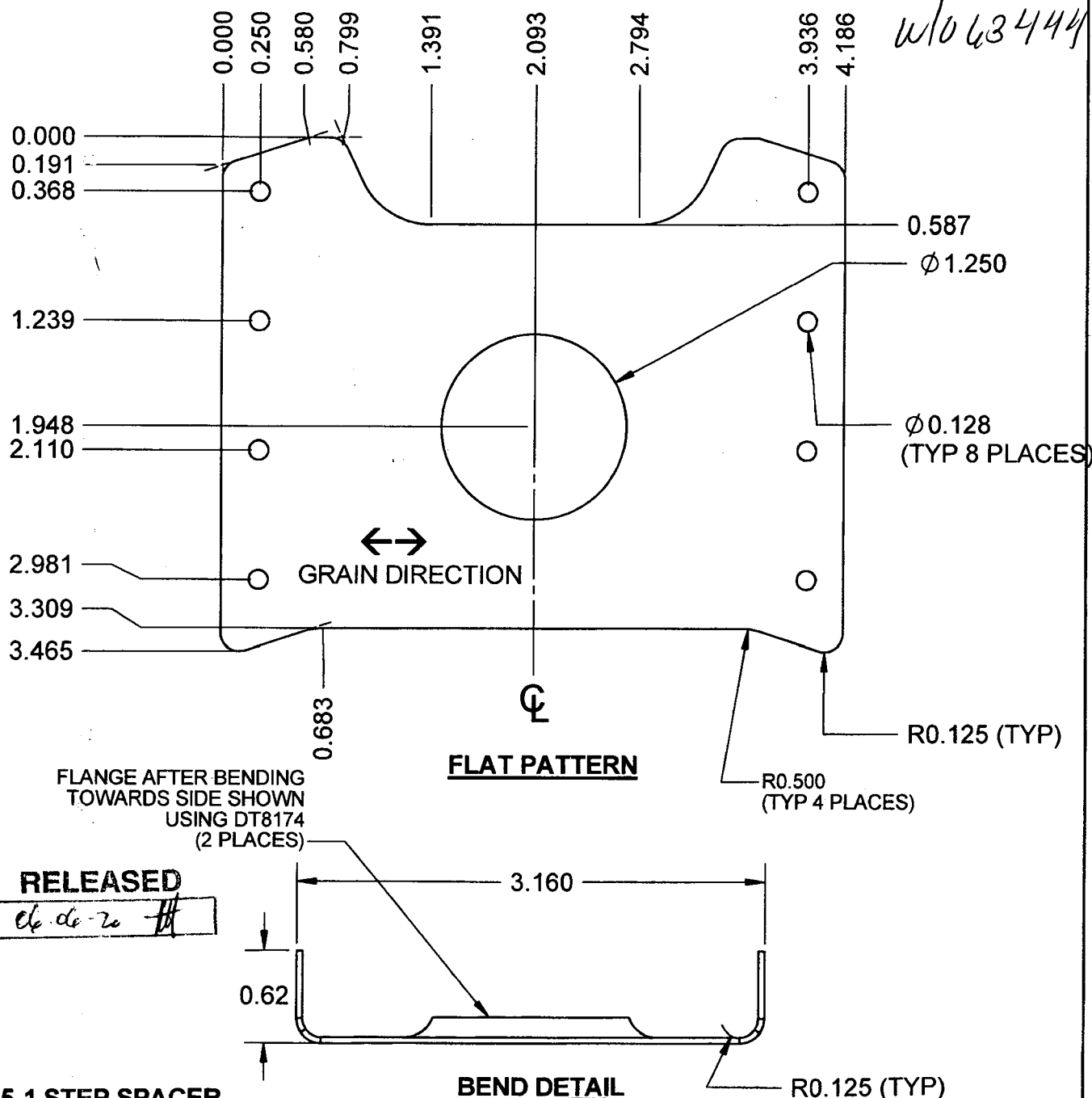
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**NOTE:** Date & initial all entries



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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3065</b>	REV. B SHEET 2 OF 5
DATE <b>06.05.23</b>	TITLE <b>STEP LEG ASSEMBLY</b>		SCALE 1:1



### D3065-1 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

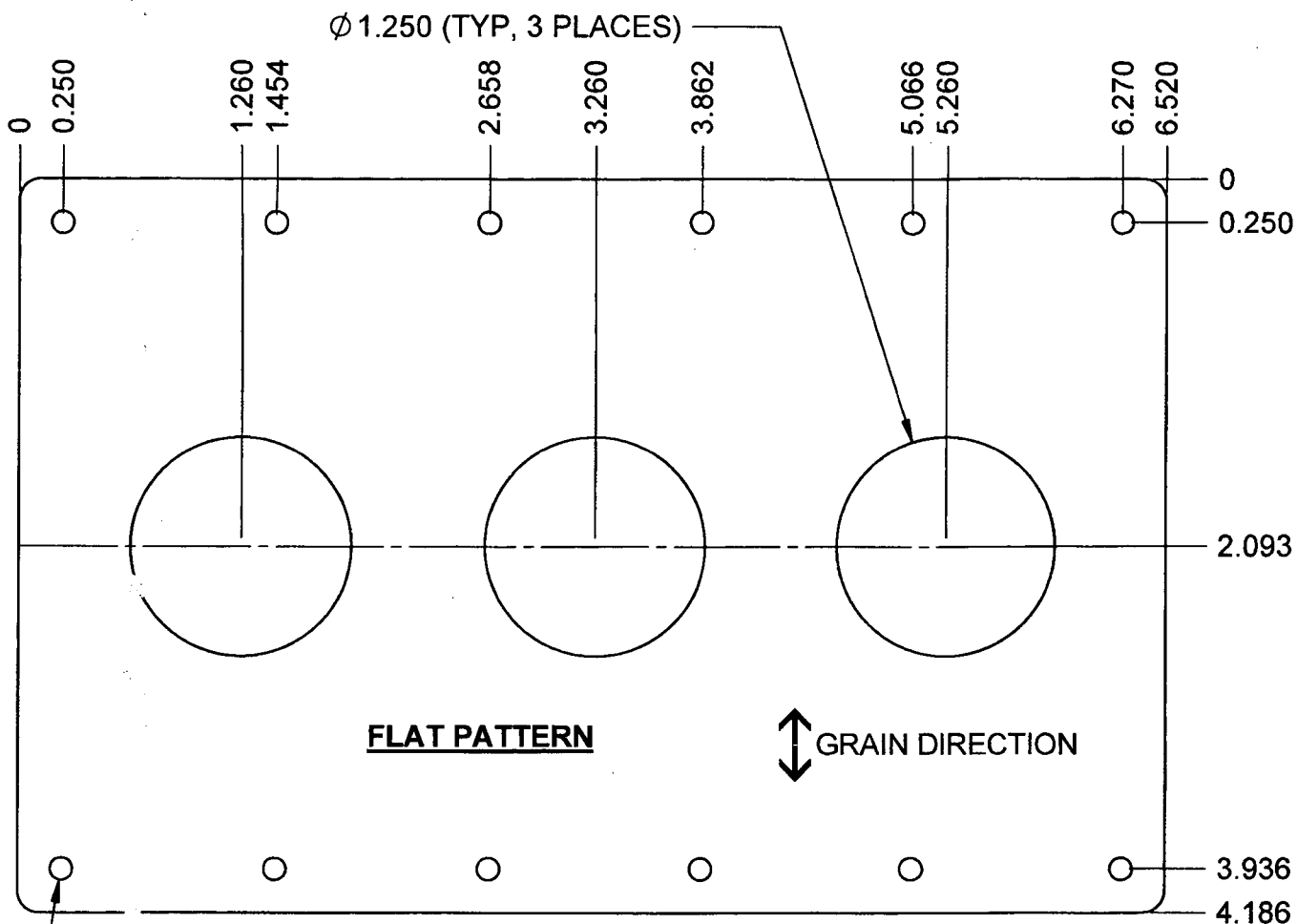
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DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1



**FLAT PATTERN**

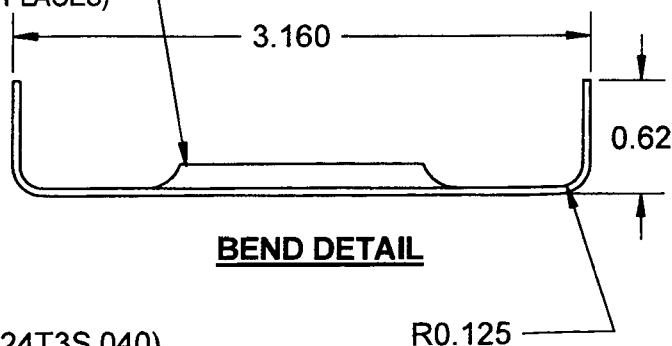
**GRAIN DIRECTION**

FLANGE AFTER TOWARDS SIDE  
SHOWN USING DT8174 (3 PLACES)

Ø 0.129 (TYP, 12 PLACES)

**RELEASED**

*Ch de 20*



**BEND DETAIL**

**D3065-3 STEP SPACER**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4)  
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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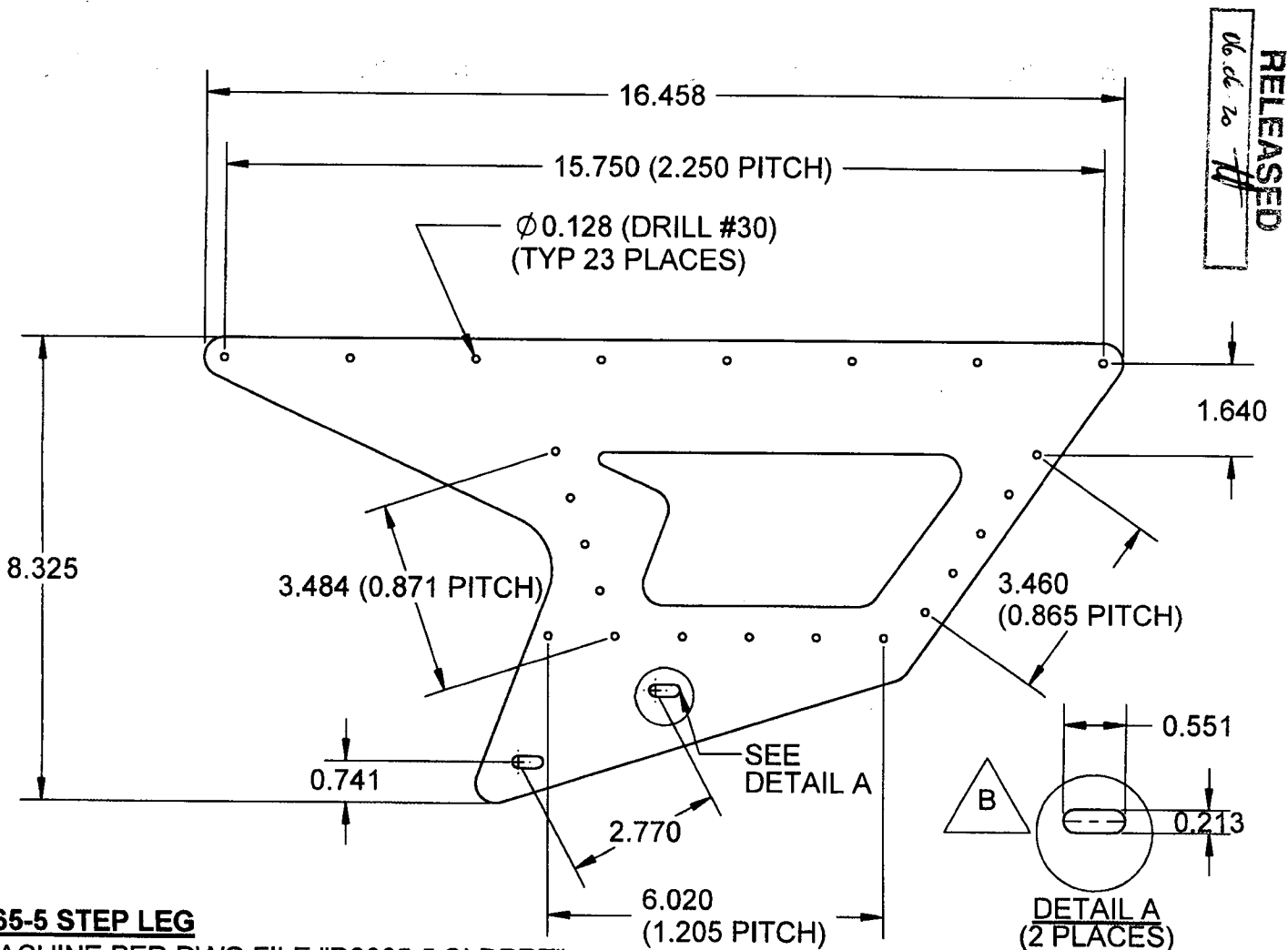
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**DART**

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CHECKED	<i>PH</i>	APPROVED	<i>PH</i>	REV. B
DATE	06.05.23	TITLE	D3065	SHEET 4 OF 5
		STEP LEG ASSEMBLY		SCALE 1:3



**D3065-5 STEP LEG**

- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
- 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK  
(REF DART SPEC M6061T6S.080)  
OR  
5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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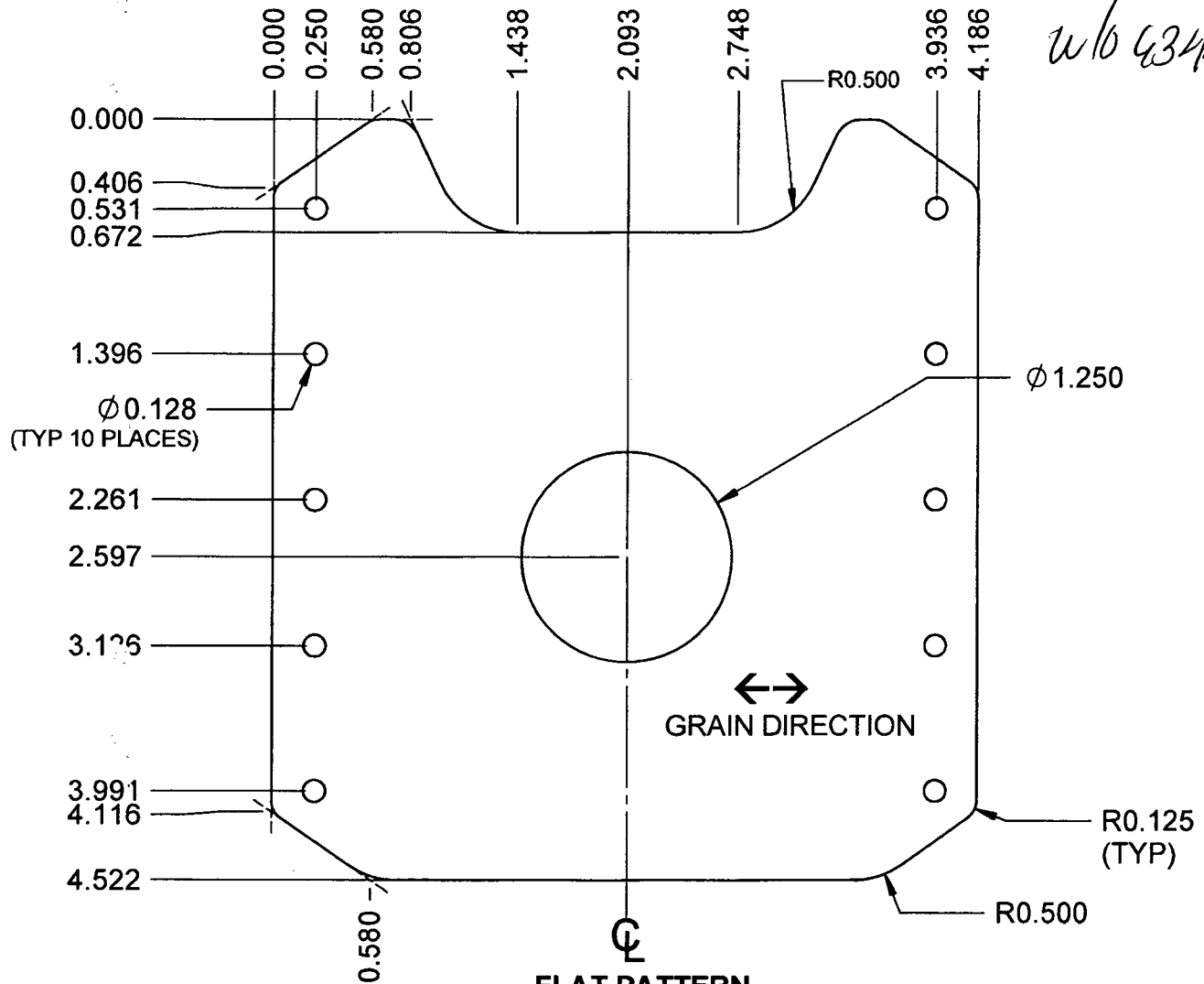
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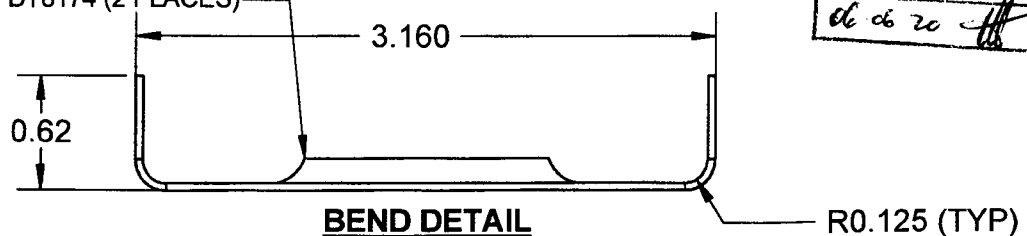
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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3065</b>	REV. B SHEET 5 OF 5
DATE <b>06.05.23</b>	TITLE <b>STEP LEG ASSEMBLY</b>		SCALE 1:1



FLANGE AFTER BENDING TOWARDS  
SIDE SHOWN USING DT8174 (2 PLACES)

**RELEASED***de de 20***D3065-7 STEP SPACER**

- 1) MATERIAL: 2024-T3 (PER QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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